

Work Order ID 111817

Wednesday, January 22, 2014 3:57:28 PM

111817

TULMAR
ASAP Page 1

Item ID: PB67-43001-173

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cover Plate

Stop

NS2

Start Date: 1/22/2014 Start Qty: 20.00

20

Cust Item ID:

Required Date: 1/31/2014 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: mw

Date: 14-1-22

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

B67-43001-173

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg B67-43001 Dwg Rev: C Prog Rev: C

****grain direction along 7.065" ****2-Debur if necessary

20 0 Jm 14-01-24

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

20 0 Jm 14-01-24

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
16
9-89

14.1.27

cut
20

ATO

DQA:

Date: 14/6/25



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 14/4/16

Work Order update only ☐

Work Order: <u>111817</u> Part No. <u>P867-43001-173</u> NCR No. <u>14-3753</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☒ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data	14/3/4	100	20	Foam: SBR/EPDM/LR BLEND, BLACK, ASTM D1556 2A2, 1/2" THK	DAS 12 9-89	Acceptable deviation	DAS 12 9-89	DAS 27 9-89	DAS 27 9-89
Equip/Tooling				ADHESIVE: LA4009NOVOC	14/3/4	Part is not AIRWORTHY	14/3/4	14/4/16	14/4/16
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Page 3

Item ID: PB67-43001-173 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cover Plate
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 Required Date: 1/31/2014 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 <i>M 11/27/14</i> Memo START TIME: <i>11:25</i> FINISH TIME: <i>11:55</i> OVEN TEMPERATURE: <i>320°</i>	0.00 0.00				<i>20</i>	<i>0</i>	<i>14-1-28</i>	DAS 34 9-89
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>20</i>			
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo <i>NAS</i>	0.00 0.00							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	PURCHASING	0.00							
200									
Purchasing	Memo	0.00							
Purchasing	SEND TO TALMAR FOR FOAM AND FABRIC								
210	Receive & Inspect for Damage & Mat'l Certs	0.00							
210									
Packaging	Memo	0.00							
Packaging									
220	QC6- Inspect dimensions to drawing	0.00							
220									
QC	Memo	0.00							
Quality Control									

P/O: 22870

CL 14/02/03 20

14/4/14 (20)

DAS
27
9-19

u/hy

20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Equip/Tooling									
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Material									
Operator									
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Process									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 111817

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Item ID: PB67-43001-173 Accept ***N900040100*** Setup Start ***NS1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Identify as per dwg & Stock Location: _____	0.00							
230									
Packaging	Memo	0.00							
Packaging	<i>MP2L2</i>								
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE 1/23/14 AUTH UP
 RELEASED UP DATE 1/24/14

CHECK FORM DENSITY

1/24/15 *(20)*

MLJ 14-04-15

MLJ 1404-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Picklist Print

Wednesday, January 22, 2014 3:57:28 PM

Page 1

Work Order ID: 111817

Parent Item: PB67-43001-173

Start Date: 1/22/2014

Required Date: 1/31/2014

Parent Item Name: Cover Plate

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 08-06-20 new issue DD verified by:ec
dwg EC verified by:DD

IPP Rev B 10.10.04 per revC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.032

Purchased

No

100

sf

363.8000

1.0548

23

2024-T3 .032 sheet

Jm14-01-24

Location

Loc Qty

Loc Code

MAT022

363.8

121309

7

123574

14

124987

10

M127668

332.8

127668

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

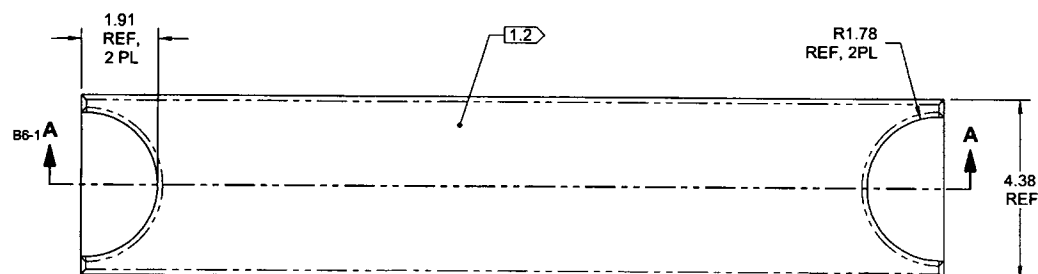
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Unapproved									

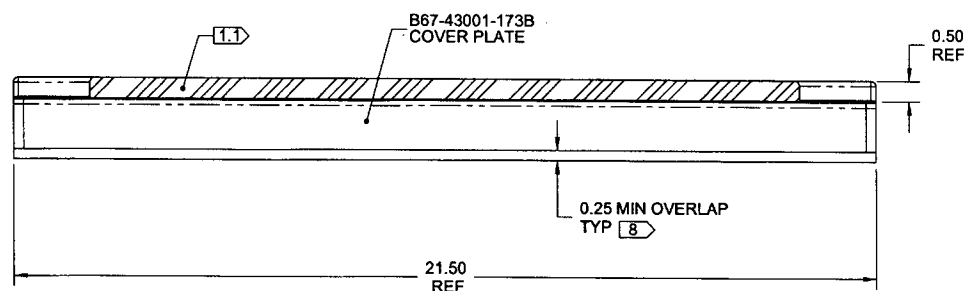
FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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ITEM	QTY -173	P/N	DESCRIPTION
1	X	B67-43001-173	COVER PLATE ASSEMBLY
2	1	B67-43001-173B	COVER PLATE
3	A/R	1637-001	SEE NOTE 1.1
4	A/R	1495	SEE NOTE 1.2
5	A/R	LA4009	SEE NOTE 1.3



B67-43001-173 COVER PLATE ASSEMBLY



SECTION A-A D8-1

NOTES:

1) MATERIAL:

1.1) FOAM: ETHYLENE PROPYLENE NEOPRENE SBR CLOSED-CELL, FLAME RETARDANT, 0.50 THICK, PER ASTM D1056 2A2, SERVICE TEMP -40°F TO +200°F, COLOUR: BLACK
REF. TULMAR P/N 1637-001

1.2) FABRIC: 100% 420 DENIER NYLON, MIN THREAD COUNT 35X35, POLYURETHANE COATED ONE SIDE, COLOUR: BLACK
REF. TULMAR P/N 1495

1.3) ADHESIVE: URETHANE WITH CATALYST, TWO PART, CLIFTON LA4009

2) FINISH: BOND NEOPRENE TO COVER PLATE USING ADHESIVE. COVER WITH DENIER AS SHOWN.

3) TOLERANCES: PER TABLE 1 (ZN A3-1) UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

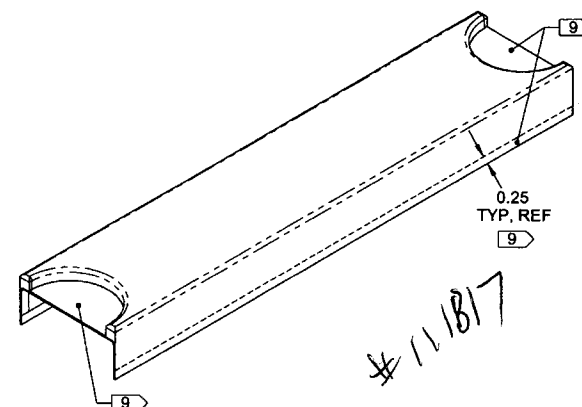
5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT: 0.78 lbs REF

8) DENIER NYLON TO BE BONDED ALL AROUND INNER SIDES OF PLATE

9) DENIER NYLON TO BE BONDED TO PLATE ON OUTER SIDE



RELEASED
2010-09-17

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018, QSI 043 AND TULMAR SAFETY SYSTEMS INC.'S MANUFACTURING PROCESS AND TOLERANCES ON FABRIC: 4.38 WAS 4.25. FOR PREVIOUS REVISIONS, REFER TO SHEETS 10 AND 27 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.27
REV	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AS			
CHECKED	AS	DRAWING NO. B67-43001-173	REV. C	
MFG. APPR.	AS	TITLE	SHEET 1 OF 2	
APPROVED	AS	COVER PLATE	SCALE	
DE APPR.	N/A		NTS	
DATE	10.04.27		COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

TABLE 1 [3]

TOLERANCES ON FABRIC (PARTS AND ASSEMBLIES)
±1/8: DIMS <2
±1/4: DIMS 2 TO <10
±1/2: DIMS 10 TO <20
±5/8: DIMS 20 TO <40
±1.5%: DIMS EQUAL TO OR > 40

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

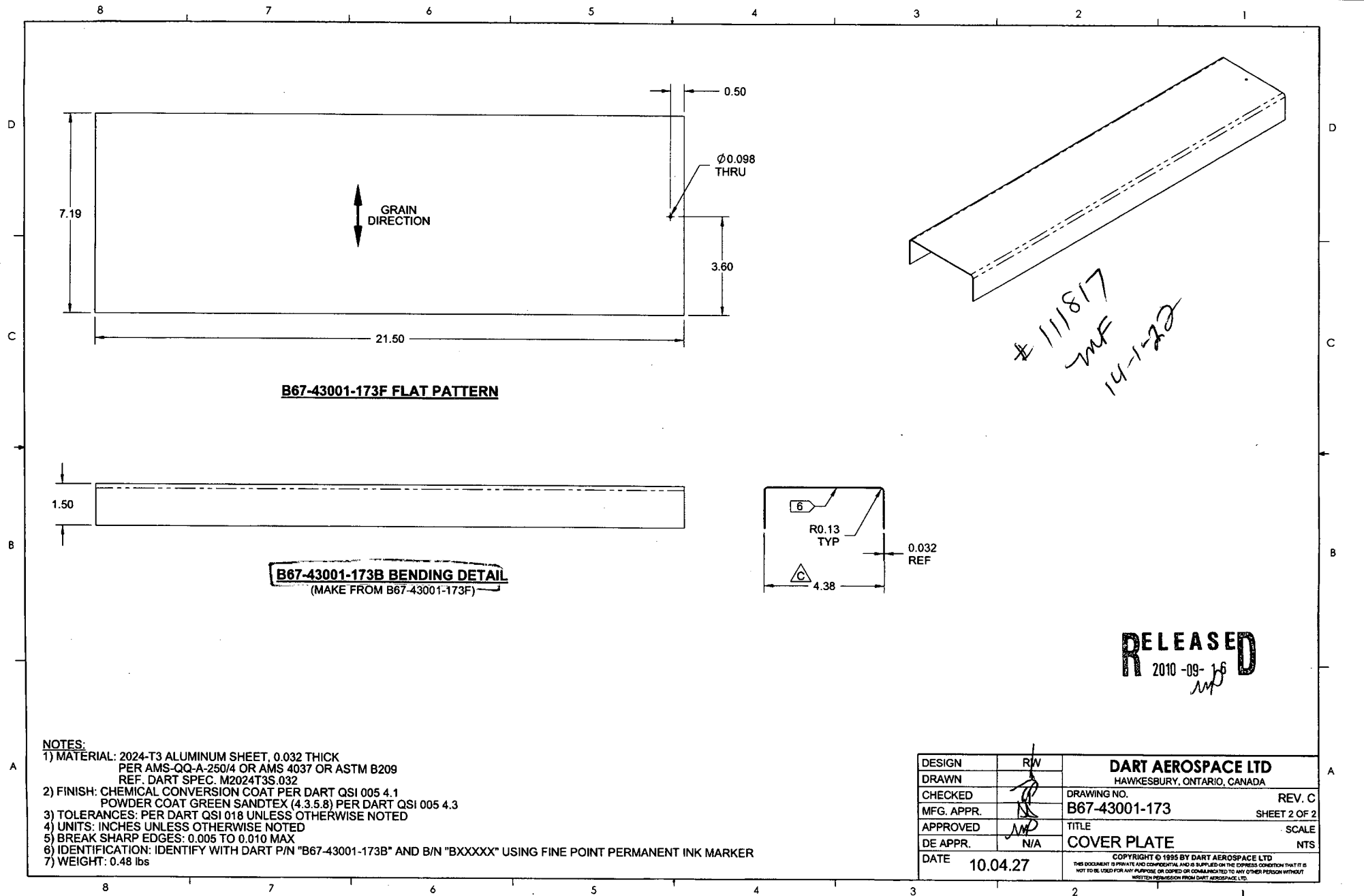
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
--	--	---	---



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

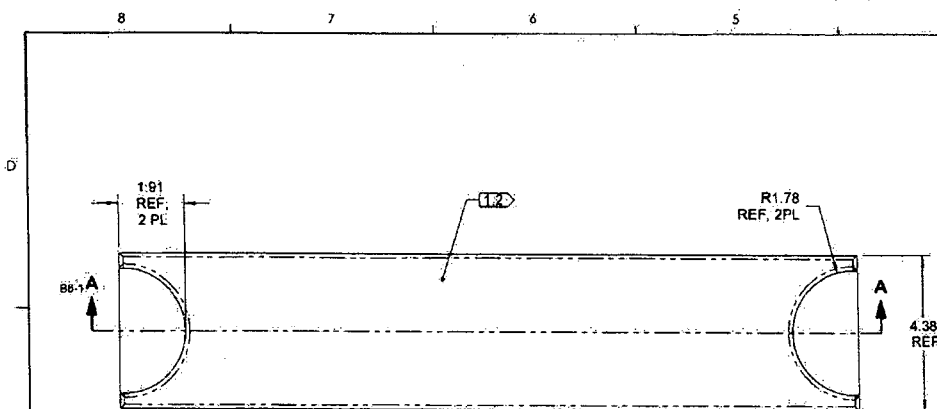
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

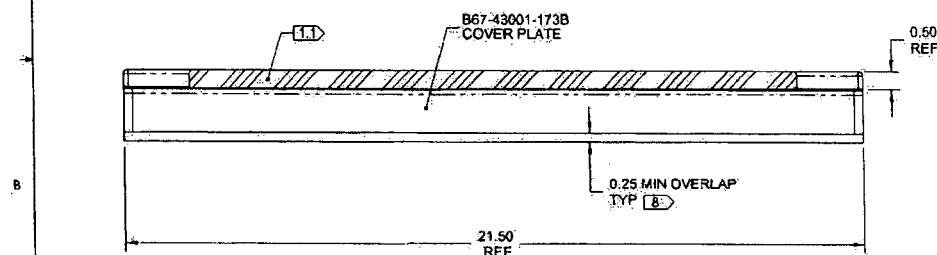
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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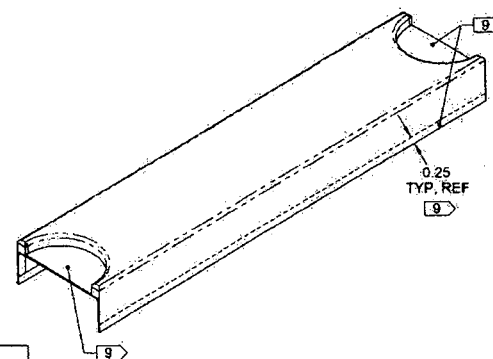
B67-43001-173 COVER PLATE ASSEMBLY



SECTION A-A D8-1

- FOAM, SBR/EPDM/CR BLEND, BLACK, ASTM D1056 2A2, 1/2" THK.,
 1) MATERIAL: BRITTLENESS TEMP OF -40F, IAW ASTM D 746, FMVSS 302.
 1.1) FOAM: ETHYLENE PROPYLENE NEOPRENE SBR CLOSED CELL, FLAME RETARDANT, 0.50 THICK,
 PER ASTM D1056 2A2, SERVICE TEMP -40°F TO +200°F, COLOUR: BLACK,
 REF: TULMAR P/N 1637-001.
 1.2) FABRIC: 100% 420 DENIER NYLON, MIN THREAD COUNT 35X35, POLYURETHANE COATED ONE SIDE,
 COLOUR: BLACK
 REF: TULMAR P/N 1495
 1.3) ADHESIVE: URETHANE WITH CATALYST, TWO PART, CLIFTON LA4009 OR LA4009NOVOC.
 2) FINISH: BOND NEOPRENE TO COVER PLATE USING ADHESIVE. COVER WITH DENIER AS SHOWN.
 3) TOLERANCES: PER TABLE 1 (ZN A3-1) UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.78 lbs REF
 8) DENIER NYLON TO BE BONDED ALL AROUND INNER SIDES OF PLATE
 9) DENIER NYLON TO BE BONDED TO PLATE ON OUTER SIDE.

ITEM	QTY	P/N	DESCRIPTION
1	X	B67-43001-173	COVER PLATE ASSEMBLY
2	1	B67-43001-173B	COVER PLATE
3	A/R	1637-001	SEE NOTE 1.1
4	A/R	1495	SEE NOTE 1.2
5	A/R	LA4009	SEE NOTE 1.3



TULMAR MARK-UP
 REV I
 02/10/2013 RL

RELEASED
 2010-09-16

C	REDRAWN PREMIER AVIATION DRAWING IAW DART OSI 018, OSI 043 AND TULMAR SAFETY SYSTEMS INC.'S MANUFACTURING PROCESS AND TOLERANCES ON FABRIC; 4.38 WAS 4.25. FOR PREVIOUS REVISIONS, REFER TO SHEETS 10 AND 27 OF PREMIER AVIATION DRAWING NO. B67-43001. REASON: SEE PARAGRAPH 011.			MB	10.04.27
	REV.	DESCRIPTION	BY	DATE	
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AS	DRAWING NO.	B67-43001-173	REV. C	
CHECKED	AS	SHEET 1 OF 2			
MFG. APPR.	AS	TITLE	COVER PLATE	SCALE	NTS
APPROVED	AS	COPYRIGHT © 1983 BY DART AEROSPACE LTD. ALL RIGHTS RESERVED. NO PART OF THIS PUBLICATION MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.			
DE APPR.	N/A	DATE	10.04.27		

TABLE 1 [3]	
TOLERANCES ON FABRIC (PARTS AND ASSEMBLIES)	
±1/8": DIMS < 2	
±1/4": DIMS 2 TO < 10	
±1/2": DIMS 10 TO < 20	
±5/8": DIMS 20 TO < 40	
±1.5%: DIMS EQUAL TO OR > 40	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO22870

Purchase Order Date 2/3/2014

PO Print Date 3/7/2014

Page Number 1 of 2

Order From :
TULMAR SAFETY SYSTEMS
1123 CAMERON ST
HAWKESBURY, ON K6A 2B8
CA

VC-TUL001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name
Vendor Phone 613 632 1282

Ship To Contact
Ship To Phone
Ship Via: VENDOR'S TRUCK
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extend Pr
----------	--	------------------------	--------------------------------------	----	--------------------------------	---------------	--------------

1	111817	PB67-43001-173 COVER PLATE	2/26/2014 Yes 3/28/2014		20.00	\$130.00	\$2,600.
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FOAM AND FABRIC AS PER DWG *REV.C+1*

NOTE: ACCEPTABLE DEVIATION PART ARE NOT AIRWORTHY
FOAM, SBR/EPDM/CR BLEND BLACK, ASTM D1056 2A2, 1/2" THK BRITTLNESS TEMP. OF-40F, IAW ASTM D 746, FMVSS 302
ADHESIVE: LA4009NOVOC

Line Total: \$2,600.

2	111756	PB67-43001-85 D-PAD ASSEMBLY, LONG	2/26/2014 Yes 3/28/2014		20.00 ✓	\$50.00	\$1,000.
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FOAM AND FABRIC AS PER DWG *REV.C+2*

NOTE: ACCEPTABLE DEVIATION PART ARE NOT AIRWORTHY
FOAM, SBR/EPDM/CR BLEND BLACK, ASTM D1056 2A2, 1/2" THK BRITTLNESS TEMP. OF-40F, IAW ASTM D 746, FMVSS 302
ADHESIVE: LA4009NOVOC

SP 14-3-27.

PO Instructions: Procurement Quality Clauses
A004 faa-pma/tso
A005 right of entry
A007 first article inspection (fai)
A016 personnel qualification
A026 certification of material conformance
A027 flammability test *146 x 10 F02 PS*
A040 notification of quality escape
A041 quality management system

** approved **
14/3/10

PACKING SLIP

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8 CA
Tel: 613-632-1282
Fax: 613-632-2030
MID : XOTULSAF1123HAW
email: info@tulmar.com

Packing Slip No.

51584

Ship Date

11-Apr-14

Bill To:

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7. Canada

Ship to:

Dart Aerospace
1270 Aberdeen Street
Tel: 613-632-9577
Att: Chantal Lavoie
Hawkesbury, ON K6A 1K7. Canada

Order number	Sales order date	Account number	Account manager
31538	4-Feb-14	CDART100	Helena Vandeweerd
PO number	Ship Via	Shipping Terms	
PO22870	Pick-Up	FOB HAWKESBURY	
Item No.	Quantity ordered	UOM	Qty Shipped/Returned
Description			Quantity on back order

QA-A027 waived

Note = Foam & Fabric as per Dwg

8421-104
Cover Plate/
Drawing No: B67-43001-173+MU
DWG Rev: C+1
A004 A005 A007 A016 A026 A040 A041
Lot No: BATCH0000000010 Qty: 20

20 EA 20

8421-103
Cover Plate/
Drawing No: B67-43001-181+MU
DWG Rev: C+1
A004 A005 A007 A016 A026 A040 A041
Lot No: BATCH0000000009 Qty: 20

20 EA 20

Shipper

Niel Reed

Date:

APR 11 2014

Certificate of Conformance

☒ See Certification Enclosed

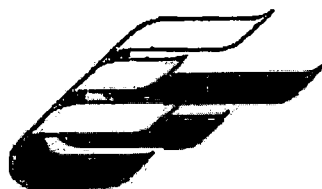
I hereby certify that the items listed hereon have been inspected, and / or tested (as applicable), conform to all specifications and requirements detailed in the contract or purchase order. Objective evidence to support this statement is on file, and can be made available upon request.
If any questions or concerns, please contact QA Manager @ 613-632-1282 ext. 245.

Authorized Inspector

Bonnie Kautler

Date:

APR 11 2014



J. ENNIS FABRICS

October 7, 2013

Fax To: Tulmar Safety Systems
Fax: 613-632-2030
Attention: Meagan

Certificate of Conformance

Re: PO 26380-00 for Oxford 7 Black

The goods shipped on P/O 26380-00 are as per sampled goods. Specification as follows:
As per mill documentation:

Oxford 7 Black is in compliance with the following standards:

Width: Product is 58 Inches Wide.

Roll Size: Average Roll Length is 75 Yards.

Weight: Product Weight is 6.79 Ounces per Sq.Yd. /Product Weight is 10.94 oz per Lin.Yd

Content: 100% Nylon

Coating: Product has a Polyurethane Coating (approximately 0.65 oz/ Sq.Yd. (18.5g/sq.yd.))

Denier: Yarn is 420 Denier.

Thread Count: Construction is 62 x 38 Threads per Square Inch

Protective Finish: Product is Water Repellent.

Hydro Resist: AATCC 127 (Suter): Average 800 mm

Piece # Various Manufacture Date: 05/17/13, Lot Number: 422038

Sincerely,
J. Ennis Fabrics Ltd.

C. Harris

Crystal Harris
Customer Service Specialist

c/c's used To mfg.

B-67-43001-173+M6

Rev A+1.

Roxanne Hawthorn April 11/14.

1495/29.



TULMAR**Certificate of Conformance**

Tulmar P/N 1637-001	Description Foam, SBR/EPDM/CR blend, black, ASTM D1056 2a2, 1/2" thick, 42"x72", brittle temp of -40°F IAW ASTM D746, FMVSS 302	Dwg # N/A	Revision -	Qty 4
Tulmar PO # 27193-00	Line Item # 1	Supplier Name / Address Am Rubber & Foam Gaskets Inc. 2074 Steeles Ave. East Units 1 & 2, Brampton On L6T 4Z9	Supplier Packing Slip # 12190	

Supplier Declarations:

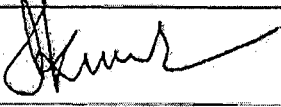
Hazardous Materials Acknowledgement	The items described below may contain, and their processing may have included, the following substances:	Hexavalent Chromium; Cadmium; Beryllium; Nickel; Mercury; Lead; Asbestos; Radioactive elements YES ☐ NO ☒
Country of Origin of Goods : CANADA		if YES, please complete the HazMat Acknowledgement form @ www.tulmar.com
Limited Shelf-Life	<u>Definition:</u> If material is consumed or transformed into final product before end of shelf-life there is no effect on final product.	These items have a limited Shelf-Life YES ☐ NO ☒
Expiry date	<u>Definition:</u> Date after which performance will no longer be as intended - expiration is transferred to the final product.	These items have an expiry date YES ☐ NO ☒

if YES, please complete the Time Expired - Shelf-Life questionnaire @ www.tulmar.com

Additional Information (MRS#, MRA#, limitations, etc...):

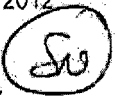
--

I hereby certify that the goods listed hereon have been inspected and/or tested, as applicable, and conform to all specifications and requirements detailed in the contract or purchase order and relevant quality clauses. Objective evidence to support this statement is on file and can be made available upon request. Should further information be required, please contact:

Signature 	Name Joseph Malhotra	Date (DD-MMM-YYYY) 02/01/2014
Title QA MANAGER	Email Joe.Malhotra@amrubber.ca	Phone # 647 501 1449

Form Revision 13 Aug 2012

TSS # 1637-001/05



TULMAR

Certificate of Conformance

Tulmar P/N 2530	Description THREAD, NYLON, 12/21/12 A-A-59826, TY2, CL. A, SIDE F, NB CAB92, QUALITY CLAUSE GAB	Dwg #	Revision	Qty 40 SP
Tulmar PO # 26542-00	Line Item # 1	Supplier Name / Address CAHYSEW INC. 111 CHABANE L W, SUITE 101 MONTREAL, QUE. H2N 1C9	Supplier Packing Slip # H 53670	

Supplier Declarations:

Hazardous Materials Acknowledgement	The items described below may contain, and their processing may have included, the following substances:	Hexavalent Chromium; Cadmium; Beryllium; Nickel; Mercury; Lead; Asbestos; Radioactive elements YES ☐ NO ☒
Country of Origin of Goods : USA		if YES, please complete the HazMat Acknowledgement form @ www.tulmar.com
Limited Shelf-Life	<u>Definition:</u> If material is consumed or transformed into final product before end of shelf-life there is no effect on final product.	These Items have a limited Shelf-Life YES ☐ NO ☒ if YES, please complete the Time Expired - Shelf-Life questionnaire @ www.tulmar.com
Expiry date	<u>Definition:</u> Date after which performance will no longer be as intended - expiration is transferred to the final product.	These Items have an expiry date YES ☐ NO ☒

Additional Information (MRS#, MRA#, limitations, etc...):

--

I hereby certify that the goods listed hereon have been inspected and/or tested, as applicable, and conform to all specifications and requirements detailed in the contract or purchase order and relevant quality clauses. Objective evidence to support this statement is on file and can be made available upon request. Should further information be required, please contact:

Signature EL S	Name HERSHIE SCHARTER	Date (DD-MMM-YYYY) 23-OCT-2013
Title PRESIDENT	Email hershie@cansew.ca	Phone # (514) 382-2807

Form Revision 13 Aug 2012

TSS 2530 / 51 

TULMAR

Certificate of Conformance

Tulmar P/N 2530	Description THREAD, NYLON, 12 AIL A-A-59826, TY2, CL. A, SIDE F, NB CAB92, QUALITY CLAUSE GAB	Dwg #	Revision	Qty 405P
Tulmar PO # 26542-00	Line Item # 1	Supplier Name / Address CHAYSEY INC. 111 CHABANE L W, SUITE 101 MONTREAL, QUE. H2N 1C9	Supplier Packing Slip # H 53670	

Supplier Declarations:

Hazardous Materials Acknowledgement	The items described below may contain, and their processing may have included, the following substances:	Hexavalent Chromium; Cadmium; Beryllium; Nickel; Mercury; Lead; Asbestos; Radioactive elements YES ☐ NO ☒
Country of Origin of Goods : USA		if YES, please complete the HazMat Acknowledgement form @ www.tulmar.com
Limited Shelf-Life	<u>Definition:</u> If material is consumed or transformed into final product before end of shelf-life there is no effect on final product.	These items have a limited Shelf-Life YES ☐ NO ☒ if YES, please complete the Time Expired - Shelf-Life questionnaire @ www.tulmar.com
Expiry date	<u>Definition:</u> Date after which performance will no longer be as intended - expiration is transferred to the final product.	These items have an expiry date YES ☐ NO ☒

Additional Information (MRS#, MRA#, limitations, etc...):

I hereby certify that the goods listed hereon have been inspected and/or tested, as applicable, and conform to all specifications and requirements detailed in the contract or purchase order and relevant quality clauses. Objective evidence to support this statement is on file and can be made available upon request. Should further information be required, please contact:

Signature EL S	Name HERSHIE SCHARTER	Date (DD-MMM-YYYY) 23-OCT-2013
Title PRESIDENT	Email hershie@cansew.ca	Phone # (514) 382-2807

Form Revision 13 Aug 2012

TSS 2530 / 51 

TULMAR

Certificate of Conformance

Tulmar P/N 2530	Description THREAD, NYLON, 12/16/16 A-A-59826, TY2, CL. A, SIDE F, NB C11392, QUALITY CLASSE GAB	Dwg #	Revision	Qty 405P
Tulmar PO # 26542-00	Line Item # 1	Supplier Name / Address CHAYSEY INC. 111 CHABANEL W, SUITE 101 MONTREAL, QUE. H2N 1C9	Supplier Packing Slip # H 53670	

Supplier Declarations:

Hazardous Materials Acknowledgement	The items described below may contain, and their processing may have included, the following substances:	Hexavalent Chromium; Cadmium; Beryllium; Nickel; Mercury; Lead; Asbestos; Radioactive elements YES ☐ NO ☒
Country of Origin of Goods : USA		if YES, please complete the HazMat Acknowledgement form @ www.tulmar.com
Limited Shelf-Life	<u>Definition:</u> If material is consumed or transformed into final product before end of shelf-life there is no effect on final product.	These items have a limited Shelf-Life YES ☐ NO ☒ if YES, please complete the Time Expired - Shelf-Life questionnaire @ www.tulmar.com
Expiry date	<u>Definition:</u> Date after which performance will no longer be as intended - expiration is transferred to the final product.	These items have an expiry date YES ☐ NO ☒

Additional Information (MRS#, MRA#, limitations, etc...):

I hereby certify that the goods listed hereon have been inspected and/or tested, as applicable, and conform to all specifications and requirements detailed in the contract or purchase order and relevant quality clauses. Objective evidence to support this statement is on file and can be made available upon request. Should further information be required, please contact:

Signature EL S	Name HERSHIE SCHANTER	Date (DD-MMM-YYYY) 23-OCT-2013
Title PRESIDENT	Email hershie@cansew.ca	Phone # (514) 382-2807

Form Revision 13 Aug 2012

TSS 2530 / 51 



ROYAL

ADHESIVES & SEALANTS, LLC

Aerospace & Marine Inflatable Adhesives & Coatings Division

Date: 11/18/13

LA4009

Shipper #: 755

Certificate of Compliance

This letter certifies that 110 x 1 gallon cans of LA4009 Polyurethane Adhesive,

**Drawing No: (Ref 10557979)

lot number: PNJ-1113-041 was shipped to you on 11/18/13. **DWG REV: "A" Royal Adhesive & Sealants,

LLC - Aerospace & Marine Inflatable Adhesives & Coatings Division manufactured this material according to internal specifications which include quality control and assurance procedures. The material was manufactured on 10/22/13 against your Purchase Order # 26618.

Shelf Life: 1 year from date of manufacture
Expiration Date: 10/22/14

This letter certifies that 19 x quart cans of CATUV Accelerator, Lot number PNJ-1113-040 was shipped to you

on 11/18/13. Royal Adhesive & Sealants, LLC - Aerospace & Marine Inflatable Adhesives & Coatings

Division manufactured this material according to internal specifications which include quality control and assurance procedures. The material was manufactured on 11/14/13 against your Purchase Order # 26618.

Shelf Life: 1 year from date of manufacture
Expiration Date: 11/14/14

Sincerely,

Dan Constantino

Daniel Constantino

Royal Adhesives & Sealants, LLC - Aerospace & Marine Inflatable Adhesives & Coatings Division
48 Burgess Place Wayne, New Jersey 07470 Phone: 973-694-0845 Fax: 973-694-5678

TSS 7122/59

TSS 7122-501/10 (80)